

Work Order ID 72711

Tuesday, August 09, 2011 11:32:50 AM



Page 1

Item ID: D4334-1

Accept



Setup Start



Revision ID:

Item Name: Swivel

Stop



Start Date: 8/9/2011 Start Qty: 3.00



ASAP
Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: mf.

Date: 11-08-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4334

A

0.00

0.00

0.00

0.00

100



Lathe Conv

Conventional Lathe

Memo

TURN AS PER DWG
DWG REV: A

DEBURR

mf 11/08/11

3 8

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

mf 11/08/11

3 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #
Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



0.00

Mill Conv

Conventional Milling Machine

Memo

MILL AS PER DWG

DWG REV: A

DEBURR

0.00

0.00

130

0.00



0.00

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

140

0.00



0.00

QC

Quality Control

QC8- Inspect parts - second check

Memo

off
B.A 11/08/11

off
B.A 11/08/11

SL 11-08-11

3

0

3

0

W/O:		WORK ORDER CHANGES					
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Revision ID:

Stop



Item Name: Swivel

Start Date: 8/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3X ϕ m-h 8/11

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3 ϕ Mb 11/08/11

170

Identify as per dwg & Stock Location: 6-A

0.00



Packaging

Memo

0.00

Packaging

w/o
72571

LS 11/08/11 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 72711

Tuesday, August 09, 2011 11:32:50 AM



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Revision ID:

Stop



Item Name: Swivel

Start Date: 8/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/11

MMF
11-08-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 09, 2011 11:32:47 AM

Page 1

Work Order ID: 72711



Parent Item: D4334-1



Parent Item Name: Swivel

Start Date: 8/9/2011

Required Date: 8/12/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No			100	f	42.0000	0.125	0.394737			



6061-T6 Round Bar 1.250

Location

Loc Qty

Loc Code

MAT013

42

113457

22

113550

20

0.395 on 11/08/11

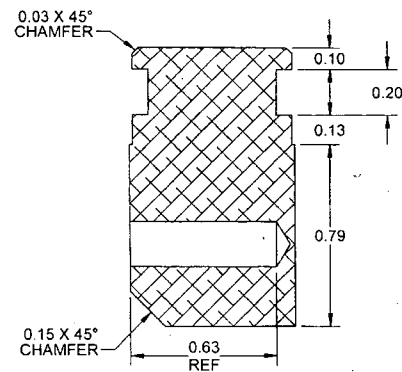
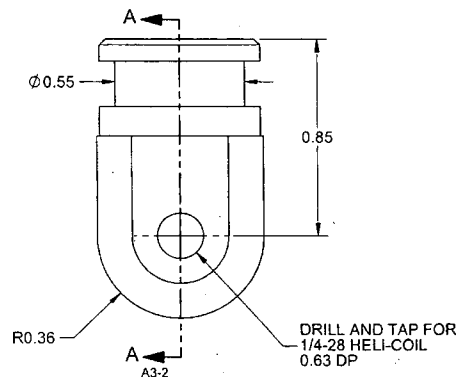
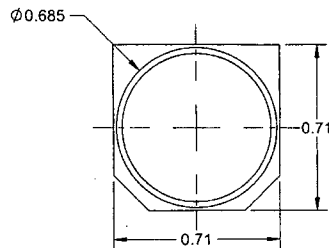
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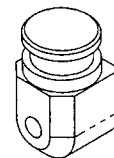
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NOTE: Date & initial all entries



SECTION A-A B6-2



72711

RELEASED
2011-05-27
LW

D4334-1 SWIVEL

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4334	SHEET 4 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 72711
Description: SWIVEL	Part Number: 04334-1
Inspection Dwg: D4334 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.685	±.010	Ø.686	—		Vern ML-7	
.71	±.030	.715	—		"	
.71	±.030	.715	—		"	
Ø.55	±.030	Ø.557	—		"	
.85	±.030	.850	—		"	
R.36	±.030	R.360	✓		R-6	
1/4-28	N/A					
.03 X 45°	±.030	.025 X 45°	—		Vern ML-7	
.10	±.030	.100	—		"	
.20	±.030	.199	—		"	
.13	±.030	.125	—		"	
.79	±.030	.791	—		"	
.63	±.030	.635	—		"	
.15 X 45°	±.030	0.152 X 45°	✓		Vern	GA-01

Measured by: <i>AK</i> / H.A.	Audited by: <i>SL</i>	Preliminary Approval:
Date: 11/08/11 11/08/11	Date: 11-08-11	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15